Blue

Work Order ID 53353

November 2, 2009 10:42:45 AM

Item ID: D3394-043
Revision ID: A
Item Name: Lug Assembly

Accept

Setup Start
Stop

Start Date: 02/11/2009 **Start Qty:** 32.00
Required Date: 13/11/2009 **Req'd Qty:** 32.00
Reference:

Cust Item ID:
Customer:

Approvals: **Process Plan:** PP **Date:** 09-11-2 **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D3394	Rev A								
100		0.00							
Bandsaw	BAND SAW	0.00 ark 09/11/03				32	0		
Jeaspa Bandsaw	**Memo** Cut Blank to .850"								
105 Haas 1									
110	Outsource process - Machining	0.00 ark 09/11/03				32	0		
Outsource5	**Memo**	0.00							
Outsource process - Machining	Send Blanks To:Metec/Mast Precision Machining☐P/O:_____☐Machine D3394-3 as per Dwg D3394								
120 QC2	Receive & Inspect for Damage & Mat'l Certs	0.00 ark 09/11/03				32	0		
Packaging	**Memo**	0.00							
Packaging									

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Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC8	QC6- Inspect dimensions to drawing	0.00				32	Ø		
QC	Memo	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00				X32	Ø		
HandFinish	Memo	0.00							
Hand Finishing									
165	QC14- Inspect Spray Paint	0.00							
QC	Memo	0.00							
Quality Control									

SA 09/11/04

ML 09/11/04

ET 09-10-10

141 Spray Paint Per QSI005 4.2
Prime B# 110918
Delfleet Paint B# 110077
Delfleet Clear B# 113053

ml 09 11 09 32

Work Order ID 53353

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Run Start
Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Small Fab	0.00							
Small Fab	**Memo**	0.00							
Small Fab	Assemble as per Dwg D3394								
						09/11/12			32
180	QC5- Inspect part completeness to step on W/O	0.00							
QC	**Memo**	0.00							
Quality Control									
			09/11/12			32	0		
190	Identify as per dwg & Stock Location:_____	0.00							
Packaging	**Memo**	0.00							
Packaging									
						9/11/13		32x	SP

Work Order ID 53353

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Start Date: 02/11/2009 **Start Qty:** 32.00
Required Date: 13/11/2009 **Req'd Qty:** 32.00
Reference:

Cust Item ID:
Customer:

Run Start
Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00					09/11/13		

MF
09-11-13

Picklist Print

November 2, 2009 10:42:52 AM

Work Order ID: 53353

Parent Item: D3394-043RevA

Parent Item Name: Lug Assembly

Comments:

Start Date: 02/11/2009 **Required Date:** 13/11/2009

Start Qty: 32.00 **Required Qty:** 32.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS35489-93		Purchased	No			100	Each	220.0000	64.0000		09/11/12	
GROMMET												

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
ST	220		
106168	29		
111424	2		
111477	89		64
112492	100		

D2423RevB1		Manufactured	No			110	f	660.9918	2.3579			
Lug Extrusion												

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
ST	660.9918221		
43722	207.263091		
44529	22.39		
45800	431.338732		2.3579

Ink 09/11/03

D3394-3PRevA		Purchased	~~No~~ N			170	Each	0.0000	32.0000		09/11/12	
Lug												

A MF 09-11-13

B53353

DART AEROSPACE LTD	Work Order:	
Description: Lug Assembly	Part Number:	D3394-~~2~~ 3
Inspection Dwg: D3394 Rev: ~~A~~ B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.450	+/-0.010	4.450	✓			
0.345	+/-0.010	.341	✓			
0.306	+/-0.010	.309	✓			
3.700	+/-0.010	3.700	✓			
0.750	+/-0.010	.750	✓			
Ø0.257	+0.005/-0.000	Ø.258	✓			
Ø0.453	+0.006/-0.001	Ø.456	✓			
0.375	+/-0.010	.374	✓			
~~R1.000~~ 1.100	+/-0.010	1.100	✓			
0.400	+/-0.010	.399	✓			
0.250	+/-0.010	.250	✓			
1.91	+/-0.030	1.905	✓			
R.~~125~~ .063	+/-.010	.063	✓			

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	09/11/03	Date:		Date:	N/A

Rev	Date	Change		Revised by	Approved
A	09.06.11	New Issue	P/O D3394-041	KJ	

QTY. -041	QTY. -043	QTY. -045	PART NUMBER	DESCRIPTION
X			D3394-041	LUG ASSEMBLY
	X		D3394-043	LUG ASSEMBLY
		X	D3394-045	LUG ASSEMBLY
1			D3394-1	LUG
	1		D3394-3	LUG
		1	D3394-5	LUG
2	2	2	MS35489-93	GROMMET

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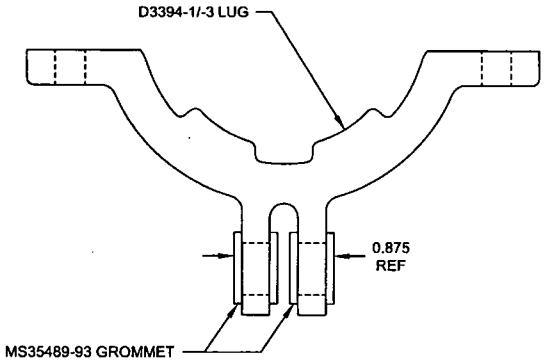
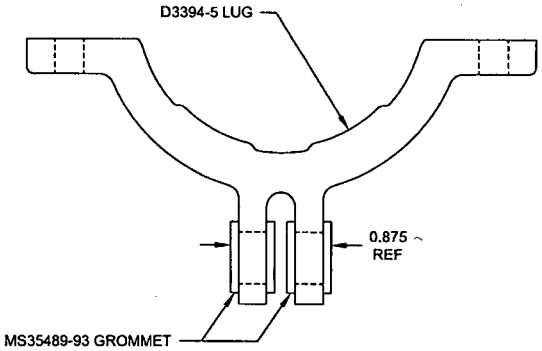
WORK ORDER
NO. 533353
BJ 09-11-2



D3394-041/-043 LUG ASSEMBLY



D3394-045 LUG ASSEMBLY

RELEASED
09/06/25 MD

NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: 0.20 lbs APPROX

REV.	DESCRIPTION	BY	DATE
B	ADDED -045. SHT 4 ADDED FILLETS IN SECTION A-A. SEE PAR 152	AJS	09.04.02
A	NEW ISSUE	PH	05.02.14

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3394	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LUG	NTS
DATE	09.04.02		

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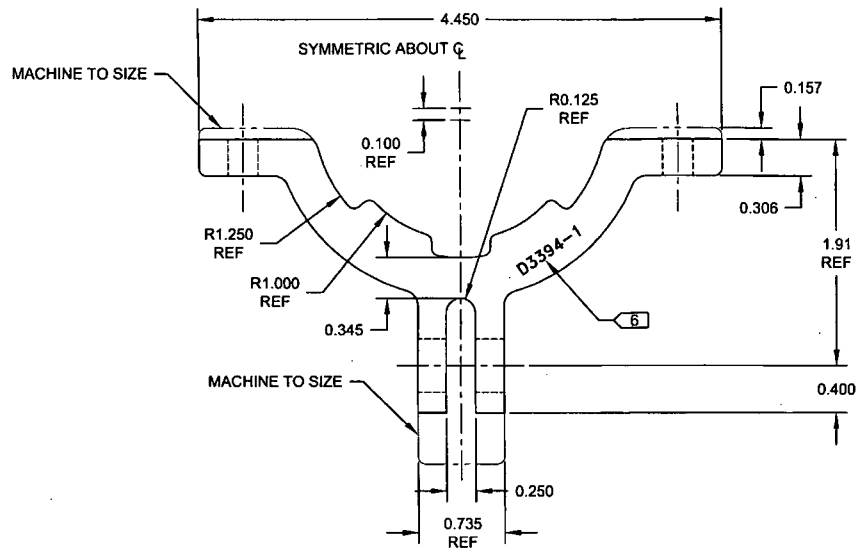

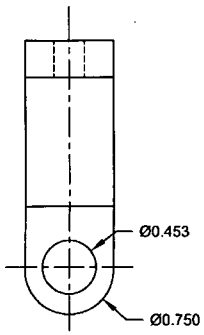

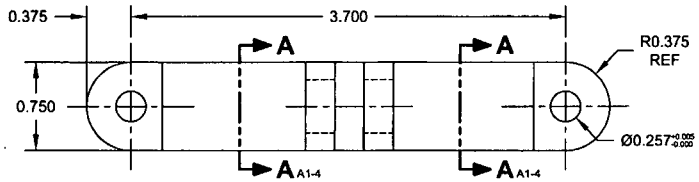

D3394-1 LUG

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NO. 53353

RELEASED
09/06/25

NOTES:
1) MATERIAL: MAKE FROM D2423
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ENGRAVE PART NUMBER TO DEPTH OF 0.010±0.005 IN THIS LOCATION, WITH TOOL A TIP RADIUS OF 0.015±0.005
7) WEIGHT: 0.18 lbs

DESIGN	PH	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	AJS	
CHECKED		DRAWING NO. REV. B
MFG. APPR.		D3394 SHEET 2 OF 4
APPROVED		TITLE SCALE
DE APPR.		LUG NTS
DATE	09.04.02	

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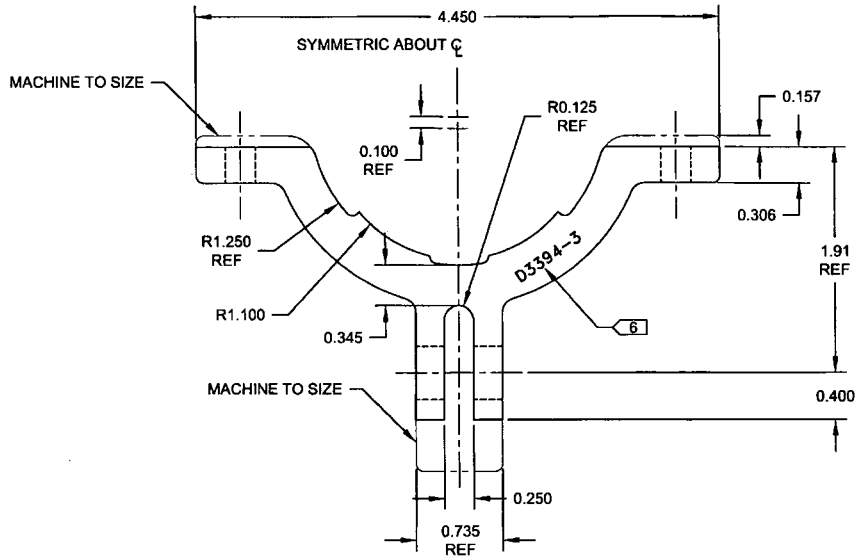

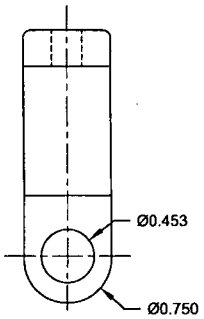

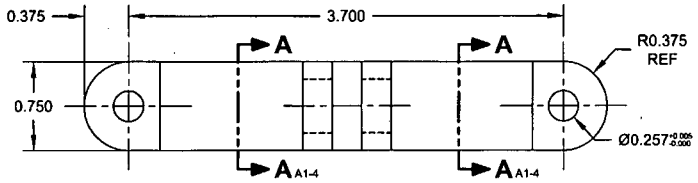

D3394-3 LUG

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7) WEIGHT: 0.18 lbs

DESIGN	PH	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	A.S	
CHECKED		DRAWING NO. REV. B
MFG. APPR.		D3394 SHEET 3 OF 4
APPROVED		TITLE SCALE
DE APPR.		LUG NTS
DATE	09.04.02	

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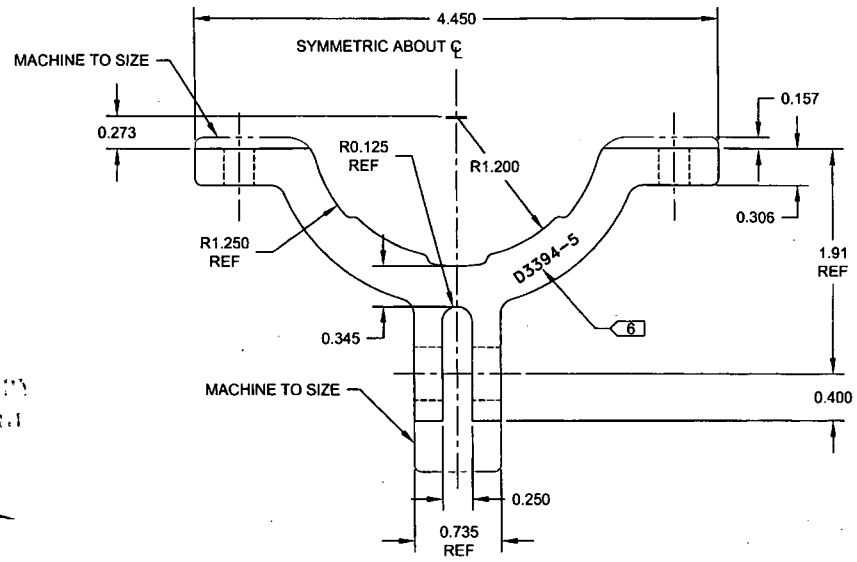
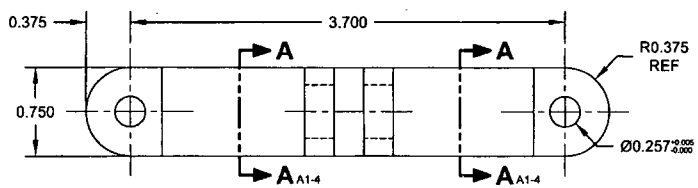
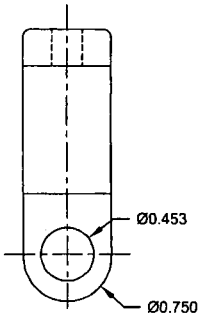
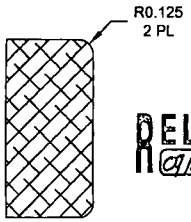




D3394-5 LUG





SECTION A-A

B5-2
B4-2
B5-3
B4-3
B5-4
B4-4

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NOTES:

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4) UNITS: INCHES UNLESS OTHERWISE NOTED
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DESIGN	PH	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	AJS	
CHECKED		DRAWING NO. D3394 — REV. B — SHEET 4 OF 4
MFG. APPR.		
APPROVED		TITLE: LUG — SCALE: NTS
DE APPR.		
DATE	09.04.02	

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